



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-827-011
Job Sheet 186374



Part No: D119-827-011

Job Qty: 2 ea

Part Name: Tail Rotor Pedal Lockout



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP REV:A 12.10.16 AS PER DWG REV:A DD VERF:JFS IPP REV:B 13-01-09 REV B JLM
VERIFIED:DD IPP REV:C 12.10.16 as per CHG002 (ecn 13-538) DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Stores/Pkg-1		NOV 23 2018 6
110	Packaging	2 pcs	12/14/18	12/14/18	0.00	0.00	Packaging1-1		DEC 03 2018 9-89
120	QC	2 pcs	12/14/18	12/14/18	0.00	0.00	QC4	DEC 03 2018	69 DAS 9-89
130	Packaging	2 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1	DEC 03 2018	69 DAS 9-89
135	DC	2 pcs	12/14/18	12/14/18	0.00	0.00	DC		21 DEC 03 2018 9-89
140	QC21-FG	2 Ea	12/14/18	12/14/18	0.00	0.00	QC21		21 DEC 03 2018 9-89

Part Op 130 - Identify and pack for shipping as per PPP D119-827-011

Descriptions: 135 - Photocopy bluefile & type labels per PPP D119-827-011 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-11A	Bolt	4 Ea (2 ea)	90-Start up Operation	5117002
D4703-041	Lock Pin Assembly	4 Ea (2 ea)	90-Start up Operation	5129406
D4704-041	Expandable Pin Assembly	2 Ea (1 ea)	90-Start up Operation	5133311
D4710-1	Spacer	2 Ea (1 ea)	90-Start up Operation	5113488
D4721-1	Decal	2 Ea (1 ea)	90-Start up Operation	5046343
MS14144L4	Nut	4 Ea (2 ea)	90-Start up Operation	5000544
MS24665-153	Cotter Pin	4 Ea (2 ea)	90-Start up Operation	1107139
NAS1149D0416J	Washer	4 Ea (2 ea)	90-Start up Operation	PM131511
NAS1149D0463J	Washer	16 Ea (8 ea)	90-Start up Operation	5092280
NAS6604D16	Bolt	4 Ea (2 ea)	90-Start up Operation	5007045

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-11A	4	82	0
	D4703-041	4	0	0
	D4704-041	2	0	0
	D4710-1	2	50	0
	D4721-1	2	14	0
	MS14144L4	4	9	0
	MS24665-153	4	486	0
	NAS1149D0416J	4	2,130	0
	NAS1149D0463J	16	2,759	0

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS					
Part No. _____				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____				Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
				Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Bending ☐ Set-up ☐ Centre Not Concentric ☐ BOM/Route ☐ Cracks ☐ Broken/Damage/Defect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Cuffs ☐ Contamination ☐ Crushing ☐ Countersink ☐ Heat Treat ☐ Cut Too Short ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Marks/Chatter ☐ Drill Holes ☐				OTHER : _____	

CONTAINER
AEROSPACE

Container No: S133838

Part: D119 - 827 - 011

Job No: 186374

Serial No/Batch: S133838

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: FAA STC SR022586 17/94/28/06/96 STC SH14 -

DART
AEROSPACE

1270 Aberdeen Street
Chesham, ON K6L 1K7
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Part Specifications

Specifications could not be found.

Plex 11/14/18 3:14 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

4.0 PARTS LIST

QTY -011	QTY -013	Part Number	Description
X		D119-827-011	TAIL ROTOR PEDAL LOCKOUT
	X	D109-827-013	TAIL ROTOR PEDAL LOCKOUT
2		D4703-041	LOCKOUT PIN ASSY
	1	D4703-045	LOCKOUT PIN ASSY
1		D4704-041	EXPANDABLE PIN ASSY
	1	D4704-043	EXPANDABLE PIN ASSY
1	1	D4710-1	SPACER
1	1	D4721-1	DECAL
	2	D5481-041	PLUG ASSEMBLY
2		AN4-11A	BOLT
	2	AN4H11A	BOLT
2		MS14144L4	NUT
2		MS24665-153	COTTER PIN
2		NAS1149D0416J	WASHER
8	2	NAS1149D0463J	WASHER
2		NAS6604D16	BOLT

5.0 WEIGHT AND BALANCE

Installation	Weight	Longitudinal		Lateral	
		Arm	Moment	Arm	Moment
D119-827-011 (A109/A119) <i>Tail Rotor Pedal Lockout</i>	0.52 lb 0.23 kg	32.6 in 0.83 m	16.9 in-lb 0.19 m-kg	-13.1 in -0.33 m	-6.8 in-lb -0.08 m-kg
D119-827-011 (206/407) <i>Tail Rotor Pedal Lockout</i>	0.52 lb 0.23 kg	33.0 in 0.84 m	17.2 in-lb 0.19 m-kg	-12.5 in -0.32 m	-6.5 in-lb -0.07 m-kg
D109-827-013 (AW109SP) <i>Tail Rotor Pedal Lockout</i>	0.54 lb 0.24 kg	32.6 in 0.83 m	17.6 in-lb 0.20 m-kg	-13.1 in -0.33 m	-7.1 in-lb -0.08 m-kg

REFERENCE ONLY

• COPYRIGHT © 2012 BY DART AEROSPACE USA INC. •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA INC.

Revision: **E**
 Date: 17.02.03

